

Work Order ID 76077

76077

Page 1

Friday, November 04, 2011 3:00:02 PM

Item ID: D2362-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Support Bracket
 Start Date: 11/4/2011 Start Qty: 4.00 ***4***
 Required Date: 11/11/2011 Req'd Qty: 4.00 ***4***
 Reference: Cust Item ID:
 Customer:

Approvals: Process Plan: Date: 11-11-07 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2362	Rev E1

100 HAAS CNC VERTICAL MACHINING #1 0.00
100
 HAAS 1 Memo 0.00
 HAAS CNC vertical machine #1 1- Mill as per Folio FA800 Rev: AA & Dwg D2362 Rev: E 2-Deburr per dwg D2362

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00
 Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Debur								
	<i>n/a</i>								
140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
140									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <i>10:15</i>								
	FINISH TIME: <i>10:45</i>								
	<i>4000F</i>								
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									

10X Ø M-12/02/06

10 BL 12-2-6.

M119480

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

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Friday, November 04, 2011 3:00:02 PM

N900040100

Setup Start *NS1*

Stop *NS2*

4

4

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

160

160

Small Fab

Small Fab

Small Fab

Memo

Bond rubber D2397-1 followed by D2397-3 using contact cement as per Dwg D2362
Batch 120225

Neoprene high performance 1300/1300L 3M

170

170

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

180

180

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

W/O:		WORK ORDER CHANGES					
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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Support Bracket

Start Date: 11/4/2011 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 11/11/2011 **Req'd Qty:** 4.00

4

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

[illegible]

190

OC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

12/2/7 *[Signature]*

MF
12-02-01

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Friday, November 04, 2011 3:00:07 PM

Page 1

Work Order ID: 76077

76077

Parent Item: D2362-3

D2362-3

Parent Item Name: Support Bracket

Start Date: 11/4/2011

Required Date: 11/11/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: G00.05.18Added inspection level 8EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2397-3		Manufactured	No			100	Each	10.0000	1	4			
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D2397-3

Rubber Cushion

**

EB 12/02/06

Location

Loc Qty

Loc Code

GA

10

72736

10

10

D2265		Manufactured	No			160	Each	70.0000	1	4			
-------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D2265

Step Bracket

**

Location

Loc Qty

Loc Code

ST488

70

44114

70

10 12-02-02

D2397-1		Manufactured	No			160	Each	11.0000	1	4			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D2397-1

Rubber Cushion

**

EB 12/02/06

Location

Loc Qty

Loc Code

GA

11

72737

11

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART



RELEASED
98.12.14 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD
BW		HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	CP	D2362
DATE	TITLE	REV. E
98.12.04	STEP SUPPORT BRACKET	SHEET 1 OF 3
A	95.02.15	NEW ISSUE
B	95.03.22	CHANGED RUBBER TO D2397
C	96.01.22	ADD D2362-5
D	97.05.21	ADD D2362-7
E	98.12.04	REDRAWN, ADD 2397-5

UNDER REVIEW

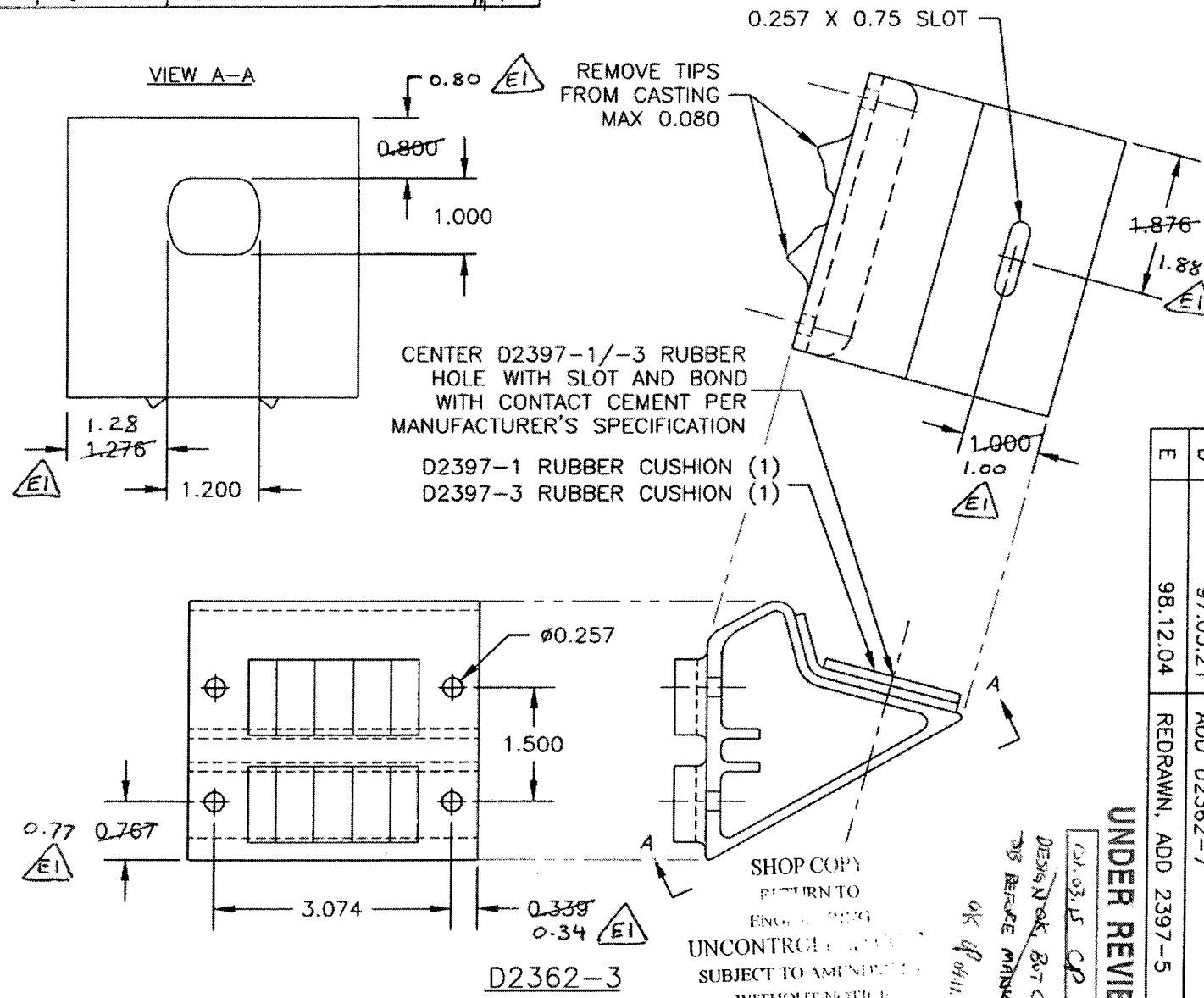
01.03.15 CP

DESIGN OK, BUT CHECK WITH
OR BEFORE MANUFACTURE
OK 04/11/04

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76027

D2362-3

EI 03.10.07 TOLERANCE CHANGE ~~RT~~



NOTES:
MAKE FROM D2265
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING RUBBER IN PLACE
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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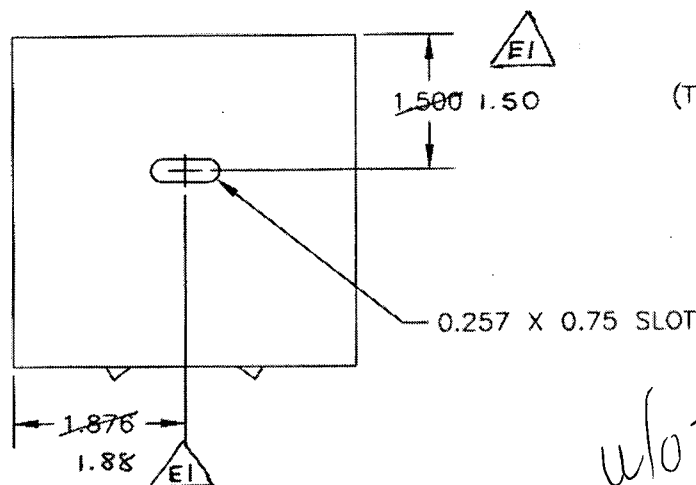
NOTE: Date & initial all entries

DART



DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD	REV. E
CHECKED	KE	APPROVED	KE	HAWKESBURY, ONTARIO, CANADA	SHEET 2 OF 3
DATE	98.12.04	TITLE	D2362	STEP SUPPORT BRACKET	SCALE 1:2

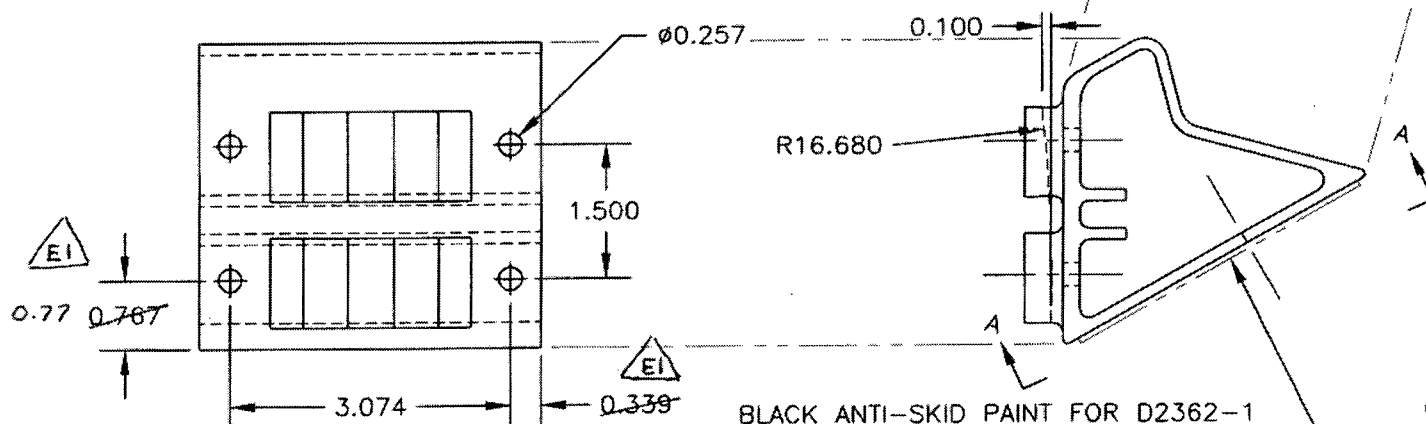
VIEW A-A



MACHINE TO R1.100 (TYP 2 PLACES)

REMOVE TIPS FROM CASTING MAX 0.080

w/076097



BLACK ANTI-SKID PAINT FOR D2362-1
INSTALL D2397-5 (1) FOR D2362-5

D2362-1 & D2362-5

NOTES:

MAKE FROM D2265

D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3

BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
98.12.14
UNDER REVIEW

DESIGNED, BUT CHECK BY DB BEFORE MANUFACTURE
OK 1/1/99

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER
QSI 005 4.3
ANTI-SKID PIAINT PER QSI 005 4.4 AFTER
POWDER COATING

MAKE FROM D2265 CASTING. DRILL D2265 AS SHOWN IN D2362-041 ASSEMBLY

NOTES:
TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

REMOVE TIPS
FROM CASTING
MAX 0.080

3.750 (REF)

BLACK ANTI-SKID PAINT

D2244-3.75

WELD PER DART 1/8
QSI 004

ø0.257

Year	Number of people in the workforce
1980	1,000
1982	1,150
1984	1,100
1986	1,250
1988	1,200
1990	1,300

0.767

3.074

0.339 0.34



UNDER REVIEW

DESIGN OK, BUT CHECK WITH
JTS BEFORE MANUFACTURE

98-12-14 KE

DESIGN BW	DRAWN BY <i>JP</i>	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA		REV. E
CHECKED <i>KE</i>	APPROVED <i>JP</i>	DRAWING NO. D2362	SHEET 3 OF 3	
DATE 98.12.04	TITLE STEP SUPPORT BRACKET		SCALE 1:2	

DART

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries